

Work Order ID 57524

April 8, 2010 7:50:11 AM

Page 1

Item ID: D3404-1

Accept

Revision ID:

Item Name: GHW Lug

Start Date: 4/08/10 Start Qty: 12.00

Required Date: 4/16/10 Req'd Qty: 12.00

Reference:

See 10-01-08

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.750" long

DJP 10/04/13

12 *Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 □ Dwg Rev: *AA* Folio Rev:
C □ 2-Debur

LF 10/04/13

12 *Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

LF 10/04/13

12 *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3404-1

Accept



Setup Start



Revision ID:

Stop



Item Name: GHW Lug

Start Date: 4/08/10 Start Qty: 12.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	10-4-14			12			
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				10-4-15		(120) SP	
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/04/19 JF MF 10-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57524



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP Rev:A 05.09.01 New issue KJ/JLM

Start Qty: 12.00

Required Qty: 12.00

IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	31.0000	2.8939			



304 BAR .750 X 2.50

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT53

31

112663

14

112697

17

2.8939

DT 10/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

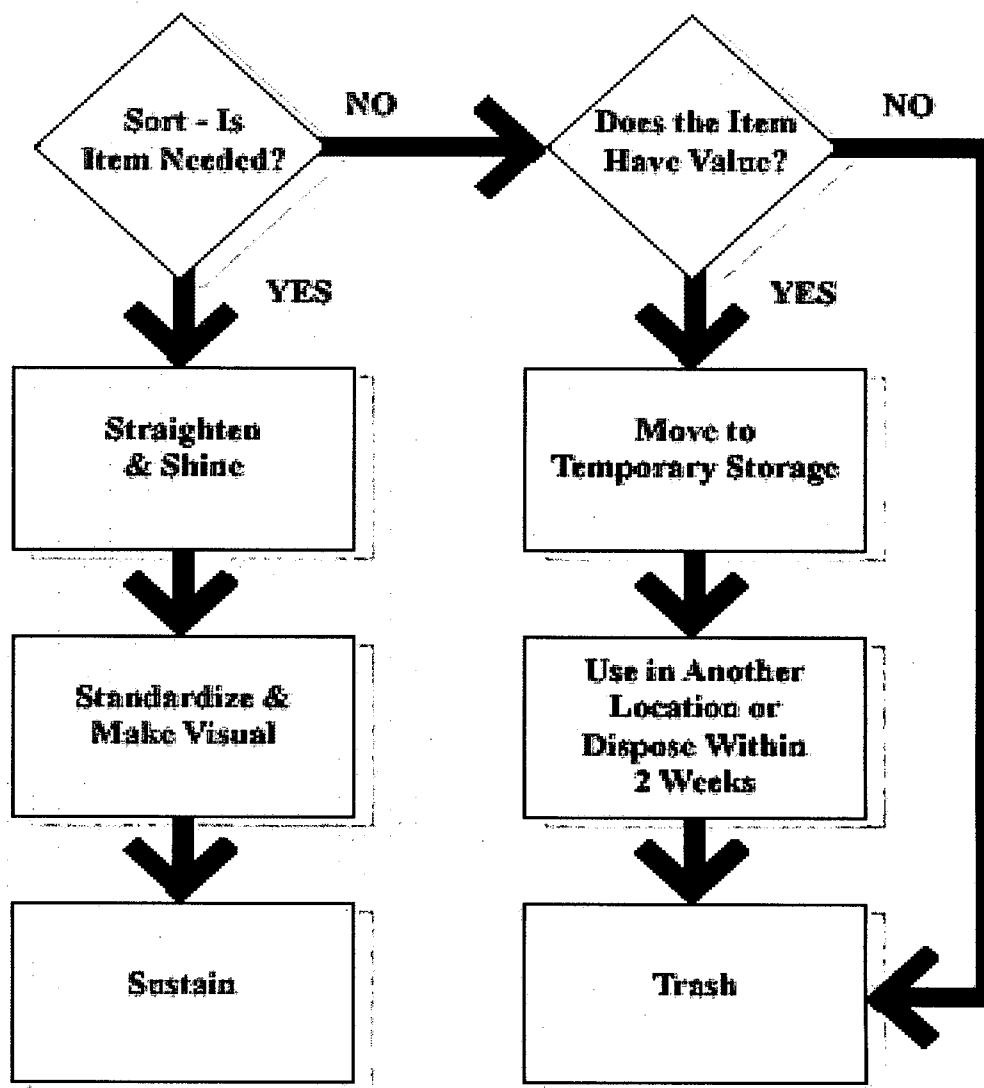
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

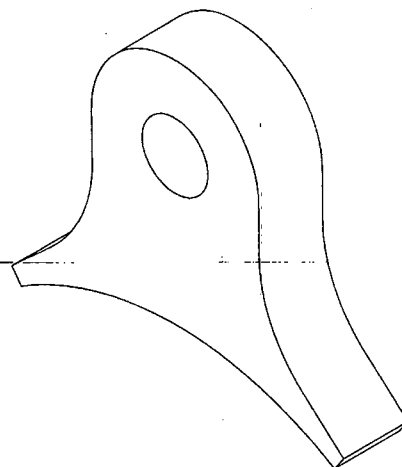
NOTE: Date & initial all entries

The following chart shows the repeatable 5S system.

5S Flow Chart



w/o 57524



D3404-1 GHW LUG

RELEASED
06/12/18/11/11

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.06.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3404 REV. C TITLE GHW LUG SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
DRAWN	AJS			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>	SHEET 1 OF 2		
DE APPR.	<i>[Signature]</i>	DATE 08.12.02		



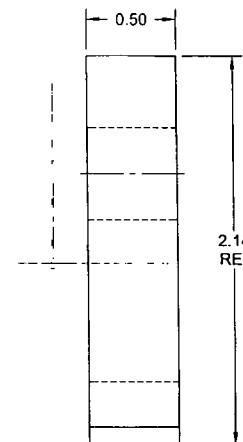
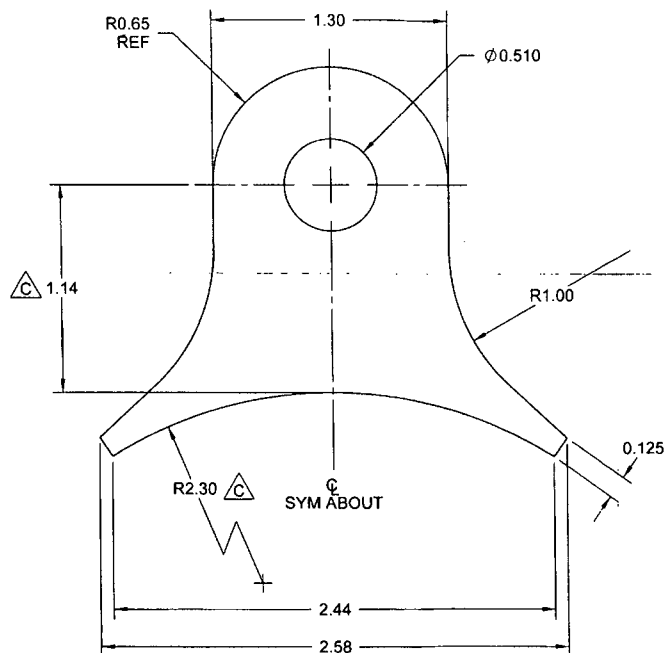
Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

- | | |
|--|--|
| 1. <i>Overproduction</i> | 2. <i>Rework</i> |
| 3. <i>Transportation</i> | 4. <i>Inappropriate / over Processing</i> |
| 5. <i>Unnecessary Inventory</i> | 6. <i>Delays / Waiting</i> |
| 7. <i>Unnecessary Motions</i> | |

w/o 57524



RELEASED
08/12/18

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DE APPR.		GHW LUG	NTS
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Lean Training Event